

Work Order ID 139374

139374

Page 1

November 26, 2015 1:15:41 PM

Item ID: D212-725-1-215F

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Shield Tail Pipe

Start Date: 11/26/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/11/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan: SH

Date: 015112 Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D212-725-1

E

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: E

Prog Rev: E

2-Deburr if necessary

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

P.T.O.

DQA:

Date:

16/01/16



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

16/01/14

Work Order update only ☐

Work Order: <u>1393784</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS				Engineering Quality ☒	
Part No. <u>D212-725-1-215F</u>		Rework ☒		Skid-tube ☐		Cross tube ☐		Water Jet ☐	
NCR No. <u>16-5527</u>		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐	
Date: <u>15.12.01</u>		Step #: <u>100</u>		QTY Effective: <u>(2)</u>		MRB (QSI042) Approval <u>A.P.</u>			
Description Work Order Deviation				Disposition				15.12.01	
0.025 THK (24 GAUGE) USED				ACCEPTABLE, OPEN PAR TO CHANGE ON D212-725-1-215F DRAWING, MTL SHOULD READ "0.025 THK (24 GAUGE)" PAR 16-432. UNACCEPTABLE METHOD FOR MATERIAL DEVIATION				Completed By <u>A.P.</u>	
								15.12.01	
								Lead hand / Supervisor Approval Verification	
				DAS 9 15.12.16 9.80				QC / QA Coordinator Approval	
				DAS 9 15.12.16 9.80					
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☒	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☒				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER: ☐							
Misidentified ☐	Past Due ☐								

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Page 2

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NS1

Revision ID:

Item Name: Shield Tail Pipe

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NS2

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Required Date: 1/11/2016 Req'd Qty: 2.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

② 15.12.16.

DAS

9

9-89

130

Identify as per dwg & Stock Location: 57500

0.00

130

Packaging

Memo

0.00

Packaging

FLAT PATTERN ONLY

2 8 000

DEC 16 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ DEC 17 2015

SA 2015 12 16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

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Work Order ID: 139374

139374

Parent Item: D212-725-1-215F

D212-725-1-215F

Parent Item Name: Shield Tail Pipe

Start Date: 11/26/2015

Required Date: 1/11/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.07.21 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA		Purchased			No	100	sf	0.0000	4.95	10.42105			

M304S25GA

304/316 .020" Sheet 304 sheet 25 GA

10.8

11/15/15

Batch: 132797

M304S25GA

DQA: _____ Date: _____

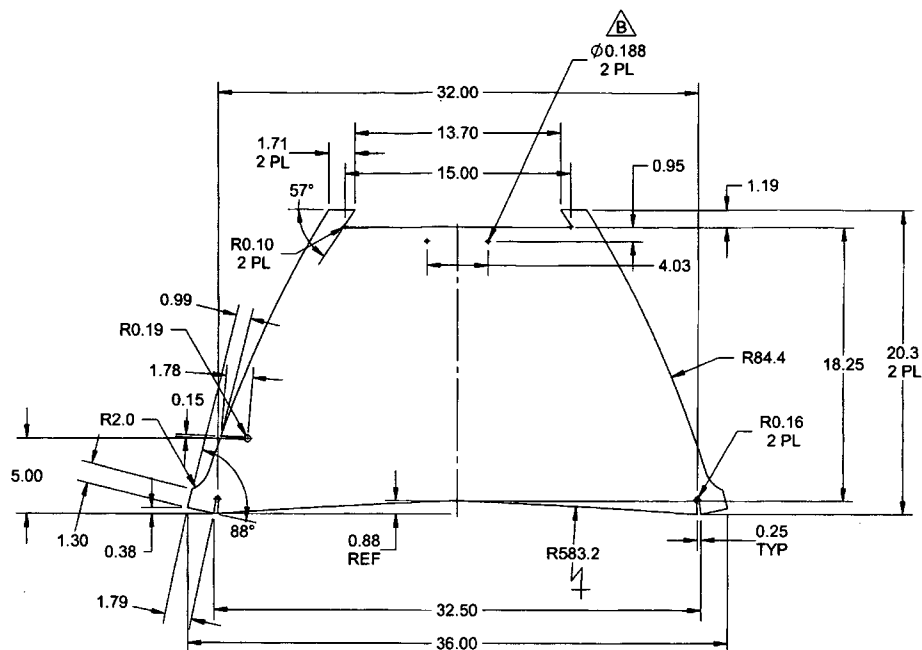


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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								Lead hand / Supervisor Approval Verification	
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							



D212-725-1-215F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 (25 GAUGE) THICK
ANNEALED
2B FINISH
PER MIL-S-5059
OR AMS-5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
REF DART SPEC. M304S25GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.00 lbs

RELEASED
2013-03-21

20151126 5#139374

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4258	SHEET 3 OF 13
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SHIELD TAIL PIPE ASSEMBLY	NTS
DATE	12.11.15	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

